

Date: Wednesday, 15/04/2009 3:04:02 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	47232		
Estimate Number :	13851		
P.O. Number :		Part Number :	D35703
This Issue :	15/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3570 REV D PRELIM
First Issue :	/ /	Project Number :	N/A
Previous Run :	47218	Drawing Revision :	D PRELIM
Written By :		Material :	
Checked & Approved By :	<u>MVF 09-04-15</u>	Due Date :	20/04/2009
Comment :	Est Rev:A New Issue 09.04.14 EC verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0746 sf(s)/Unit Total: 0.1491 sf(s)
 6061-T6 .125 Sheet
 Batch: 110062 1B 9-4-16

Grain must be Along 4.63"**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3570
 Dwg Rev: PRE
 Prog Rev: Lim

1B 9-4-16

2-Deburr if necessary

1B 9-4-16

(3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE1B 9-4-16

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK09-04-16 (3)

(PIL)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 09/04/23
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47232</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05 Oct 22</u>	<u>4.0</u>	<u>Scrap due to design change.</u> <u>RC: prelim design</u>	<u>[Signature]</u>	<u>scrap: destroy Qty 3</u> <u>No replace.</u>	<u>EP</u> <u>09/04/23</u>	<u>SN</u> <u>09/04/23</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 3:04:02 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47232

Part Number: D35703

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

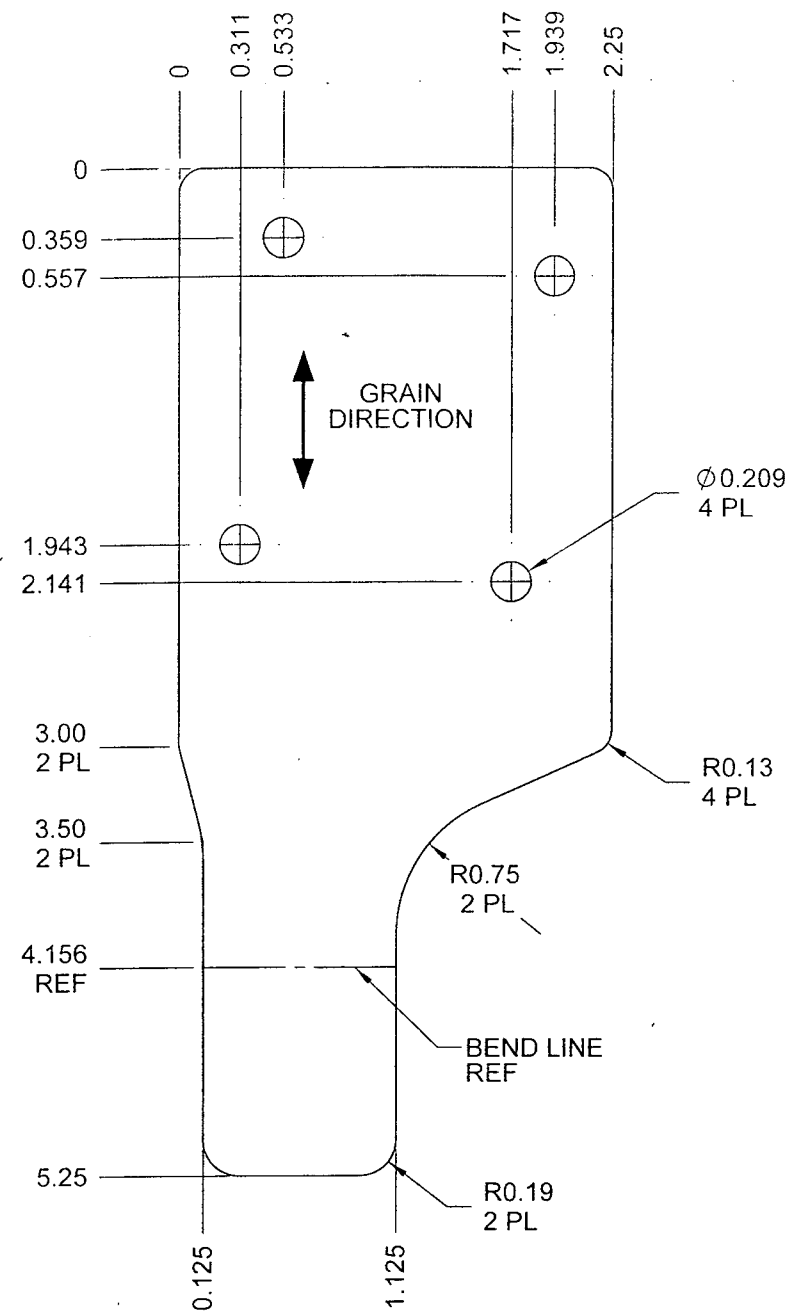
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

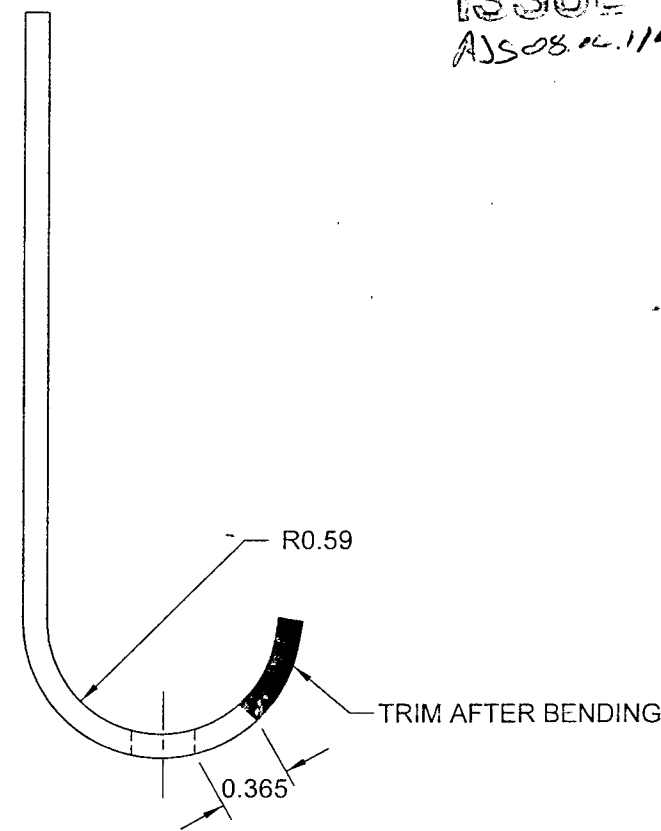
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

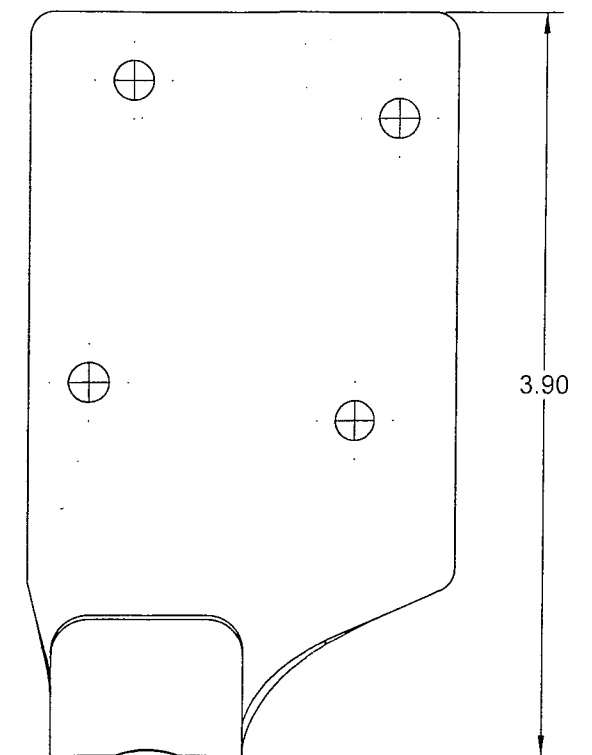
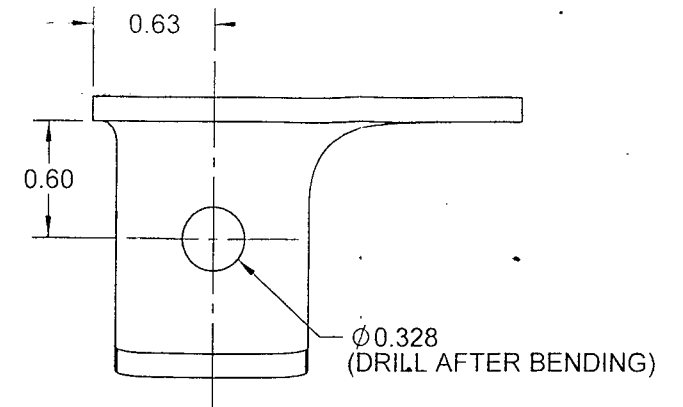
NOTE: Date & initial all entries



D3570-3F FLAT PATTERN



**PRELIMINARY
ISSUE**
AJS 08.10.114



D3570-3 BRACKET
(MAKE FROM D3570-3F)

47232

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3570	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.04.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	